



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5467-1

Job Sheet 187833



Part No: D5467-1

Job Qty: 4 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Machining-4		SBZ 18/01/05
100	CNC Vertical Machining	4 pcs	1/11/19	1/11/19	0.00	5.60	HAAS1-1		SBZ 19/01/06
120	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC1		SBZ 19/01/06
130	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC8 Machining-4		SBZ 19/01/07
140	HandFinish	4 pcs	1/11/19	1/11/19	0.00	1.20	HandFinish1		P.R 19/01/08
150	SprayPaint	4 pcs	1/11/19	1/11/19	0.00	0.10	Spray Paint		NOT REQUIRED
160	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC14		
170	Packaging	4 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2	5/399	JAN 18 2019
180	QC21-SA	4 Ea	1/11/19	1/11/19	0.00	0.00	QC21		JAN 21 2019

Part Op 100 - Program Batch No 514209 Double check by: [Signature] 1-Machine Step No 1 per Folio FB550 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB550 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB550 and inspect

120 - Inspect on CMM as per folio CMMA022. DWG REV: _____ CMM PROG. REV: _____

150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT

BATCH: _____

163 outsource-Aster-80042233 - 02 19-01-10
165: Receiving 16 JAN 17 2019 X4 PCS
167: QC 6 JAN 17 2019 68

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	5133600 5142089

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	4	17	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____ Date : _____ Description Work Order Deviation _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Hold ☐ Sequence # ☐ Qty Affected	DEPARTMENT/PROCESS Part: D5467-1 Job No: 187833 Serial No/Batch: S142090 Revision: A Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/06/19	DART AEROSPACE Container No: S142090 1270 Aberdeen Street Hamilton, ON K6A 1K7 CANADA TEL: 1 513 632-5200 Email: sales@dartaero.com www.dartaerospace.com	☐ (on-AW) ☐ Coord. ☐ Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____				
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors	FAULT CATEGORY <table style="width: 100%;"> <tr> <td style="width: 33%;"> ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled </td> <td style="width: 33%;"> ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function </td> <td style="width: 33%;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up </td> <td style="width: 33%;"> ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread </td> </tr> </table> Other/Details: _____				☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					

DART AEROSPACE LTD		Work Order: 187 833
Description: OUTER FWD SADDLE		Part Number: D5467-1
Inspection Dwg: 05467 Rev: A		Page 1 of 1

INSPECTION DIMENSION

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	1,438	1,443		1,438	1,438	1,438	1,438	
AB	1,745	1,755		1,750	1,750	1,750	1,750	
AC	3,495	3,505		3,500	3,500	3,500	3,500	
AD	7,490	8,010		7,498	7,498	7,498	7,498	
AE	1,490	1,510		1,503	1,503	1,501	1,501	
AF	1,257	1,262		1,258	1,258	1,258	1,258	
AG	1,375	1,380		1,375	1,375	1,375	1,375	
AH	1,490	1,510		1,501	1,501	1,501	1,500	
AI	1,174	1,184		1,179	1,179	1,179	1,179	
AJ	1,558	1,578		1,569	1,569	1,569	1,568	
AK	1,174	1,184		1,179	1,179	1,179	1,179	
AL	1,490	1,500		1,495	1,495	1,495	1,495	
AM	2,495	2,505		2,500	2,500	2,500	2,500	
AN	3,869	3,879		3,874	3,874	3,874	3,874	
PAO	1,15	1,135		1,132	1,130	1,132	1,132	
QAP	1,15	1,135		1,125	1,125	1,125	1,125	
RAQ	1,240	1,260		1,251	1,251	1,252	1,251	
SAR	1,15	1,135		1,128	1,128	1,128	1,126	
VAS	1,230	1,250		1,241	1,242	1,241	1,242	
WAT	1,15	1,135		1,120	1,120	1,119	1,121	
ZAU	1,353	1,373		1,366	1,366	1,366	1,366	
ALAY	1,053	1,073		1,057	1,057	1,057	1,055	
ABAW	1,615	1,635		1,625	1,625	1,626	1,625	
AEAX	1,375	1,395		1,385	1,385	1,387	1,387	
AIAX	1,490	2,010		2,000	2,000	2,000	2,000	
ADAZ	1,240	1,260		1,250	1,251	1,251	1,251	
AH	1,240	1,260		1,248	1,250	1,250	1,249	
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: DAS	Checked by: <i>mf</i>	QC Inspector:
Date: 57 19/01/06 9-89	Date: 19/01/07	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042232



Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO042232
PO Date: 1/10/19
Due Date:
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187832	D5466-1	Saddle, Fwd, In : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
						4 X	JAN 17 2019				
2	187833	D5467-1	Saddle, Fwd, Out : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
						4 X	JAN 17 2019				



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PURCHASE ORDER PO042232



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	187834	D5468-1	Saddle, Aft, Out : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
4	187835	D5469-1	Saddle, Aft, In : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00

Grand Total: \$400.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.